

Work Order ID 51156-2

August 4, 2009 3:46:12 PM



Page 1

Item ID: D3686-041

Accept



Setup Start



Revision ID: C

Item Name: MONOPOD ASSEMBLY

Stop



Start Date: 08/10/2009 Start Qty: 5.00

Cust Item ID:

Required Date: 08/21/2009 Req'd Qty: 5.00

Customer:

Reference:

Approvals: Process Plan: *mf*

Date: *09-05-04*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3686

Rev C

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

803 09/03/28

2 8

110

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Use anti-seize compound Tectly 502c Class 1, Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3686-2-Assemble D3693-1 & D3691-1 & D3693-3 & D3688-7 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3686-***Ensure holes for AN3C B

803 09/03/29

2 8

2 8

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> 5 02/09/01

(x2) 8

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51156

August 4, 2009 3:46:12 PM



Page 2

Item ID: D3686-041

Accept



Setup Start



Revision ID: C

Stop



Item Name: MONOPOD ASSEMBLY

Start Date: 08/10/2009 Start Qty: 5.00



Cust Item ID:

Required Date: 08/21/2009 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: 135

0.00



Packaging

Memo

0.00

Packaging

Per 9/9/01 (2)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/02 MF 09-09-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

August 4, 2009 3:46:12 PM

Page 1

Work Order ID: 51156



Parent Item: D3686-041RevC



Parent Item Name: MONOPOD ASSEMBLY

Start Date: 08/10/2009

Required Date: 08/21/2009

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C10A		Purchased	No			110	Each	66.0000	10.0000			

Bolt

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	66	
102116	7	
105940	59	

AN3C12A

Purchased

No

110

Each

635.0000

10.0000



Bolts

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	635	
106993	7	
110155	2	
110552	4	
110584	72	
111916	50	
112314	500	

10 8/10/08/28

10 8/10/08/28

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 2

August 4, 2009 3:46:12 PM

Work Order ID: 51156



Parent Item: D3686-041RevC



Parent Item Name: MONOPOD ASSEMBLY

Start Date: 08/10/2009

Required Date: 08/21/2009

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3688-7RevB

Manufactured

No

110

Each

18.0000

5.0000



STUD

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

18

44686

1

46055

12

46699

5

D3689-1RevB

Manufactured

No

110

Each

19.0000

5.0000



SLEEVE

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

19

46051

19

D3691-1RevU/R

Manufactured

No

110

Each

17.0000

5.0000



STUD

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

17

46052

17

3 SD 08/08/31

5 SD 08/08/31

4 SD 08/08/31

August 4, 2009 3:46:12 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Page 3

August 4, 2009 3:46:12 PM

Work Order ID: 51156



Parent Item: D3686-041RevC



Parent Item Name: MONOPOD ASSEMBLY

Start Date: 08/10/2009

Required Date: 08/21/2009

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3692-1RevB		Manufactured	No			110	Each	106.0000	20.0000			
SPACER												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

106 B50736

20

44827

68

SB 09/08/31

45672

38

D3692-3RevB

Manufactured No

110

Each

97.0000

20.0000



SPACER

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

97

20

44690

97

SB 09/08/31

August 4, 2009 3:46:12 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

Page 4

August 4, 2009 3:46:12 PM

Work Order ID: 51156



Parent Item: D3686-041RevC



Parent Item Name: MONOPOD ASSEMBLY

Start Date: 08/10/2009

Required Date: 08/21/2009

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3693-1RevU/R		Manufactured	No			110	Each	33.0000	5.0000			
Rod End Bearing												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	5	
45723	5	
Main Warehouse		
ST127	28	
50734	28	

D3693-3RevU/R

Manufactured No

110

Each

8.0000

5.0000



Rod End Bearing

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	8	
45724	8	

B 50 723

2
3

SS 08/28/31

SS 09/02/31

August 4, 2009 3:46:12 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

August 4, 2009 3:46:12 PM

Work Order ID: 51156



Parent Item: D3686-041RevC



Parent Item Name: MONOPOD ASSEMBLY

Start Date: 08/10/2009

Required Date: 08/21/2009

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21043-3 		Purchased	No			110	Each	5,590.000	20.0000			
Nut												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	80	
103691	80	
Main Warehouse		
ST	5510	
111819	210	
112243	300	
112314	5000	

NAS509L12C



Purchased

No

110

Each

135.0000 5.0000



Nuts

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	135	
106993	5	
110844	30	
112314	100	

80 09/08/31

80 09/08/31

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09/08/28	110	add NMS 509-12 C	N 112453	Ss	09/08/28	5		
				NA	09/08/28			

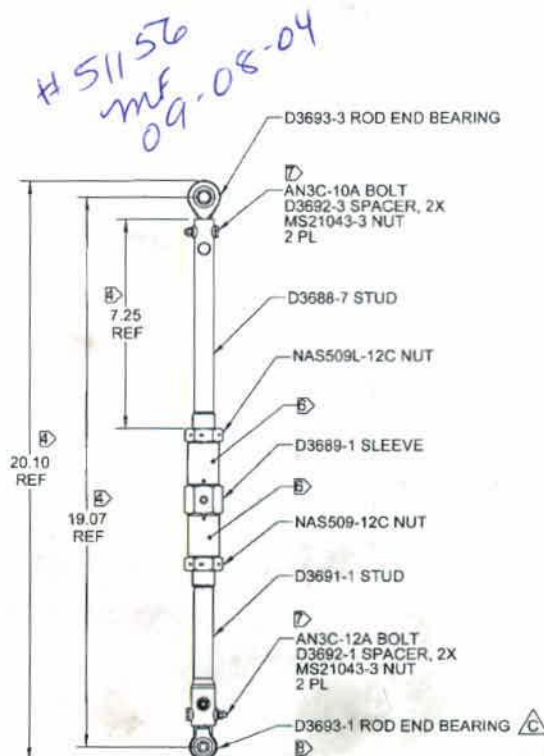
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D3686-041	MONOPOD ASSEMBLY
2	1	D3688-7	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	4	D3692-3	SPACER
7	1	D3693-1	ROD END BEARING
8	1	D3693-3	ROD END BEARING
9	2	AN3C-10A	BOLT
10	2	AN3C-12A	BOLT
11	4	MS21043-3	NUT
12	1	NAS509L-12C	NUT
13	1	NAS509-12C	NUT



D3686-041 MONOPOD ASSEMBLY

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3686-041 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSIONS SHOWN ARE WHEN D3688-7 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.0 lbs
- 6) USE TECTYL 502C CLASS 1, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 & D3693-3 WITH D3688-7 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

RELEASED
09/01/12

DESIGN	RF	DART AEROSPACE LTD	REV. C
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	SHEET 1 OF 1
CHECKED		DRAWING NO. D3686	SCALE NTS
MFG. APPR.		TITLE MONOPOD ASSEMBLY	
APPROVED			
DE APPR.			
DATE	08.12.15		

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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